

Work Order ID 57452

April 7, 2010 9:54:34 AM



Page 1

Item ID: D135-692-011

Accept



Setup Start



Revision ID:

Item Name: Bearpaw

Stop



Start Date: 07/04/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 16/04/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: *PP*Date: *12/14/07*

Tooling:

Date:

Run Start



QC: _____

Date: _____

SPC (Y/N):

Date: _____

Stop

Sequence ID/
Work Center IDOperation
Description

Draw Nbr

Revision Nbr

D3049

Rev A1

100

Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

DOCUMENT CONTROL

0.00

DC

Document Control

Memo

Photocopy bluefile and create labels per PPP D135-692-011 CHG002

8/16/12

150



Pick Kit

0.00

Packaging

Packaging

Memo

0.00

8/16/12 G

160



QC4- 100% Inspect kits for completeness

0.00

QC

Quality Control

Memo

0.00

*8/16/12**X8*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

170

Operation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Packaging

Packaging

0.00

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D135-692-011

Location:

PPP Rev: C

180



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Packaging	0.00							
	Memo	0.00							
	Identify and pack for shipping as per PPP D135-692-011								
	Location:								
	PPP Rev: C								
180	QC21- Final Inspection - Work Order Release	0.00							
	Memo	0.00							

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Picklist Print

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Work Order ID: 57452



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Parent Item: D135-692-011



Parent Item Name: Bearpaw

Start Date: 07/04/2010

Required Date: 16/04/2010

Comments: IPP Rev:C 04.02.17 Blank size changed, Tolerance added Step 3 KJ/JLM
IPP Rev:D 08-04-16 Added Step 2 JLM Verified By:EC

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3049-1 4Y		Manufactured	No				Each	0.0000	8.0000		B 57452	
Bearpaw		Purchased	No				Each	25.0000	16.0000			
OS100-M24S 4Y												
S 4Y Clamp												

Warehouse
Location

Main Warehouse

ST449
114236

Loc Qty

Loc Code

25
25
160
Each
499.0000 32.0000

114236

Purchased

No

Warehouse
Location

Main Warehouse

ST358
114239
114292

Loc Qty

Loc Code

499
40
459
160
Each
0.0000 32.0000

114292

Purchased

No

Warehouse
Location

Main Warehouse

ST358
114239
114292

Loc Qty

Loc Code

499
40
459
160
Each
0.0000 32.0000

114292

Purchased

No

AN960JD416 8Y



Washer

N/A61149 904630

PC 04/12 (4)

W/O:		WORK ORDER CHANGES					
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Parent Item: D135-692-011



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Required Date: 16/04/2010

Comments: IPP Rev:C 04.02.17 □ Blank size changed, Tolerance added Step 3 □ KJ/JLM

Start Qty: 4.00

IPP Rev:D 08-04-16 Added Step 2 JLM Verified By:EC

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2182B		Manufactured	No			160	f	403.2500	8.0000			

Rubber Cushion

74 @ 6.0 long

Measured
5/10/12

Warehouse

Location

Main Warehouse

ST402A 12

30872 12

Main Warehouse

ST410 391.25

52649 391.25

Manufactured No

160 Each 193.0000 32.0000



52649

C 10/4/12 (4)

D2274



Radius Block

Warehouse

Location

Main Warehouse

ST010 193

55602 76

56686 117

55602

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item Name: Bearpaw

Start Date: 07/04/2010

Required Date: 16/04/2010

Comments: IPP Rev:C 04.02.17 □ Blank size changed, Tolerance added Step 3 □ KJ/JLM
IPP Rev:D 08-04-16 Added Step 2 JLM Verified By:EC

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name <i>D2519</i>	Replacement Item ID	Mfg/ Purch Manufactured	Bin Item No	Primary Location	Last Location	Route Seq ID 160	Unit of Measure Each	Qty on Hand 64.0000	Remaining Qty To Pick 16.0000	Qty Issued	Date Issued	Status
<i>Clamp</i>												

Warehouse

Location

Main Warehouse

ST402A -4

48402 -4

Main Warehouse

ST456 68

56763 68

Manufactured No

160 Each 218.0000 32.0000



56763

Warehouse

Location

Main Warehouse

ST017 218

56184 218

56184

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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IPP Rev:D 08-04-16 Added Step 2 JLM Verified By:EC

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L4-8X S4 Nut		Purchased	No			160	Each	1,590.000	32.0000			7/4/12 G

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST139	2	
111827	2	
Main Warehouse		
ST300	1588	
113422	580	
114108	1000	
9063	8	

W/O:		WORK ORDER CHANGES					
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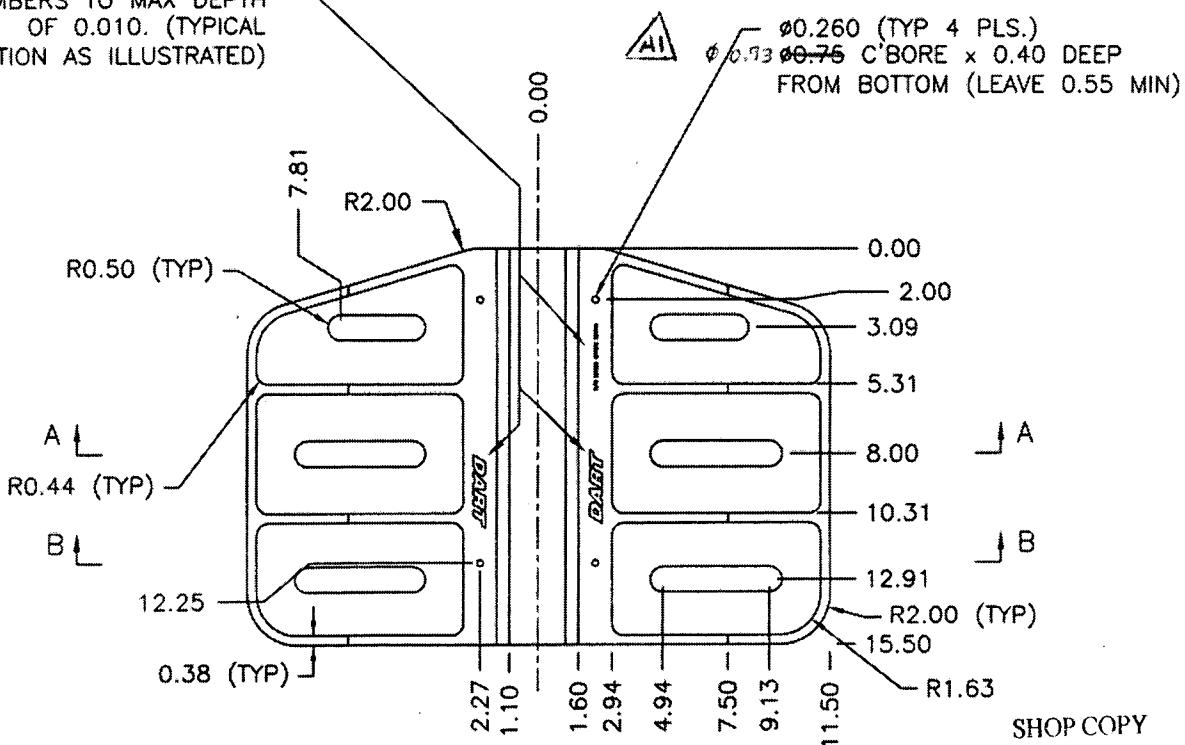
NOTE: Date & initial all entries

DARTISSUED
COPY

DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3049	REV. A SHEET 1 OF 2
DATE 01 10.18		TITLE BEARPAW	SCALE 1:7
A	01.10.18	NEW ISSUE	
AI	<i>RF 03.01.13</i>	$\phi 0.73 \text{ w } 45 \phi 0.75$	

RELEASED
01.10.24

ENgrave DART logo to
max depth of 0.012.
Engrave part and batch
numbers to max depth
of 0.010. (typical
location as illustrated)

D3049-1 BEARPAW

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57152

BJ 10-11-07

NOTES:

- 1) BEARPAW IS SYMMETRIC ABOUT CENTER LINE
- 2) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689,
1.00" THICK (MACHINE TO 0.950)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

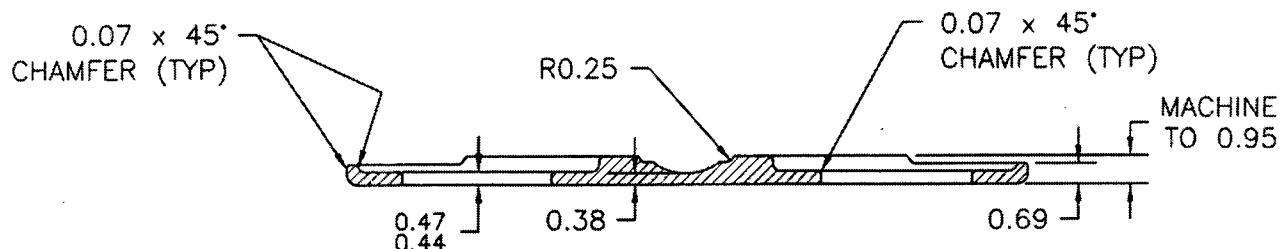
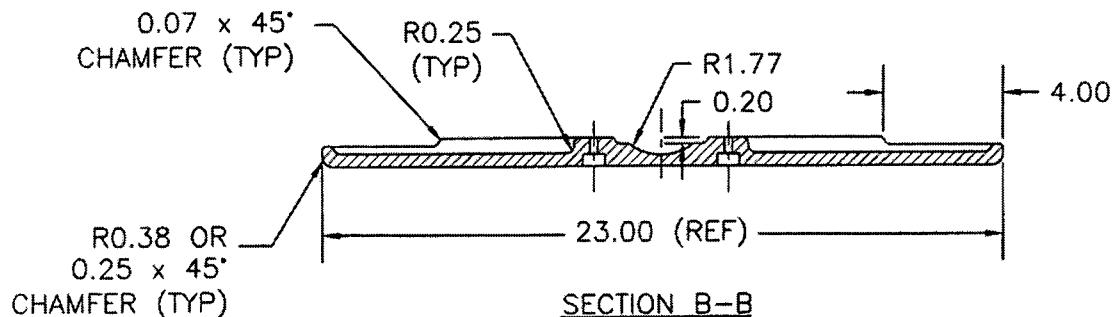
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DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3049	REV. A SHEET 2 OF 2
DATE 01.10.18		TITLE BEARPAW	SCALE 1:6

RELEASED
01.10.24 *[initials]**w/o 57452*

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32.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D135-692-011 Bearpaw Installation on model EC135 aircraft	11.8 lb 5.36 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	199.7 in 5.07 m	2356 in-lb 27.2 m-kg

32.4 PARTS LIST

Qty	Part Number	Description
X	D135-692-011	BEARPAW INSTALLATION
4	D2182B060	RUBBER CUSHION
8	D2274	RADIUS BLOCK
2	D3049-1	BEARPAW
8	D2529	WASHER
8	D2519	CLAMP
8	AN4-15A	BOLT
8	AN960JD416	WASHERS
8	MS21042L4	NUT (OR MS21042-4)
4	QS100M24S	CLAMP

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32-00-00

W/O:		WORK ORDER CHANGES					
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